

Date: Monday, 1/7/2008 3:38:46 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BEARING ASSEMBLY
Job Number	: 36638		
Estimate Number	: 11136		
P.O. Number	: <i>N/A</i>	Part Number	: D3183045
This Issue	: 1/7/2008	Drawing Number	: D3183 REV C1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i>	Drawing Revision	: C1
Previous Run	: 36369	Material	: <i>N/A</i>
		Due Date	: 1/16/2008
Written By	: <i>[Signature]</i>	Qty:	<i>58</i> Um: Each
Checked & Approved By	: <i>[Signature]</i> 08.01.8		
Comment	: Est A 04.02.18 New issue KJ/DS		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MDELINR1000	Delrin Round Bar 1"
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Comment: Qty.: 0.0350 f(s)/Unit Total : 1.3986 f(s)
 Delrin Round Bar 1" *4.0000*
 Material: Ø1.00 Delrin Rod
 (M-DELIN-R1.000)
 Identify as D3183-9
 Batch: *M103164*

J.F.

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
-----	----------	--------------------------



Comment: HARDINGE CNC LATHE SMALL
 Turn D3183-9 Cap as per Folio FA388
 Deburr

J.F. 08/01/14

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 08/01/14

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

*J.F. 08/01/15**(100)*

5.0	D31835	Bearing
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s)
 Pick: *B36648 XSD*

Qty Part Number	Description	Batch
1 D3183-5	Bearing	<i>B36387 X8</i>

*J.F. 08/01/15**(58)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08/01/15	8	42- D3183-9 sth alone w/o 36638	U	08-01-15	42	U	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 08/01/16

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/7/2008 3:38:46 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARING ASSEMBLY

Job Number: 36638

Part Number: D3183045

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press D3183-5 Bearing into D3183-9 Cap as per Dwg D3183.

mk 08/01/15

(58)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

sf 08-01-15

(58)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *8775*

DS 08/01/15

(X58)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/01/16

(58)

Job Completion



u 08/01/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

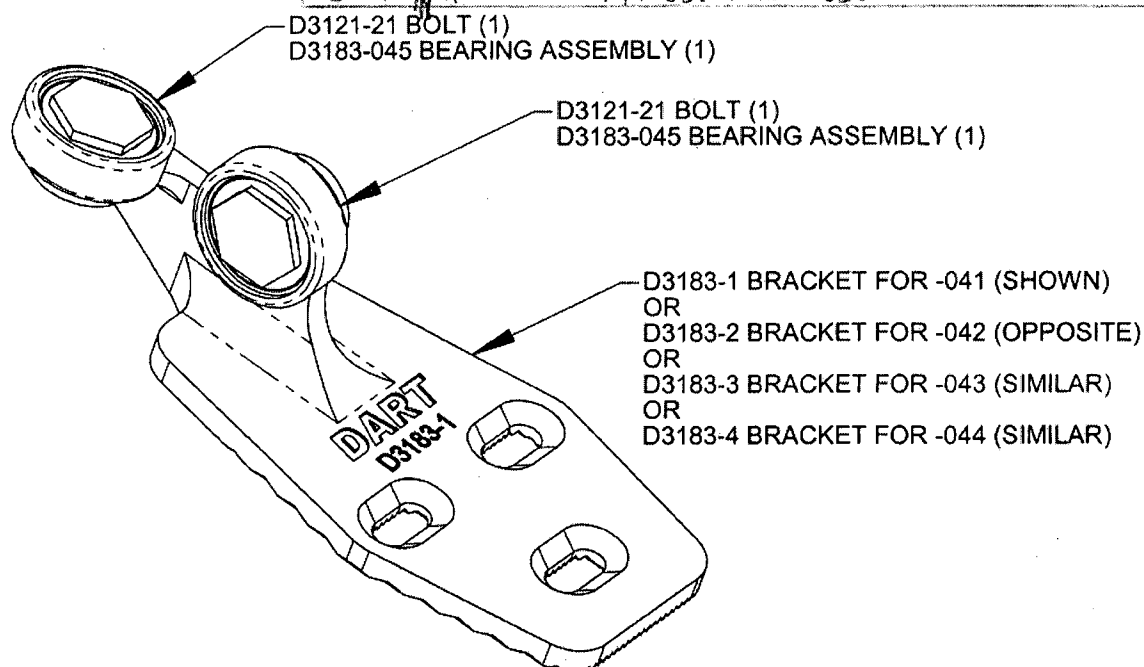
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

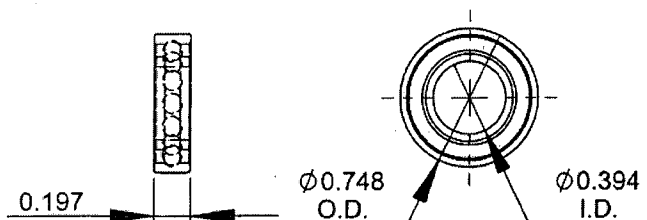


DESIGN #	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3183	REV. C SHEET 1 OF 4
DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:1
A.	03.01.24	NEW ISSUE	
B.	03.06.17	REMOVE BEARING; 1.012 WS 0.882	
C.	04.02.17	ADD -045/-9; 0.182 WAS 0.431	
CI	04.11.09	0.830 WAS 0.850	

RELEASED
04.03.01



D3183-041 BRACKET ASSEMBLY (SHOWN)
D3183-042 BRACKET ASSEMBLY (OPPOSITE)
D3183-043 BRACKET ASSEMBLY (SIMILAR)
D3183-044 BRACKET ASSEMBLY (SIMILAR)



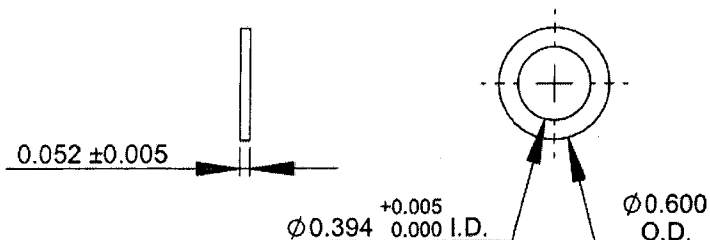
D3183-5 BEARING:
SPECIFICATION CONTROL DRAWING

- 1) SINGLE ROW, DEEP GROOVE, CONRAD TYPE, SHIELDED
- 2) POSSIBLE SUPPLIER: NSK P/N 6800ZZ
- 3) ALL DIMENSIONS ARE IN INCHES

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WITHOUT NOTICE
WORK ORDER
36638

D3183-7 WASHER

- 1) MATERIAL: AISI 303 ROUND BAR (M303R) ANNEALED
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES



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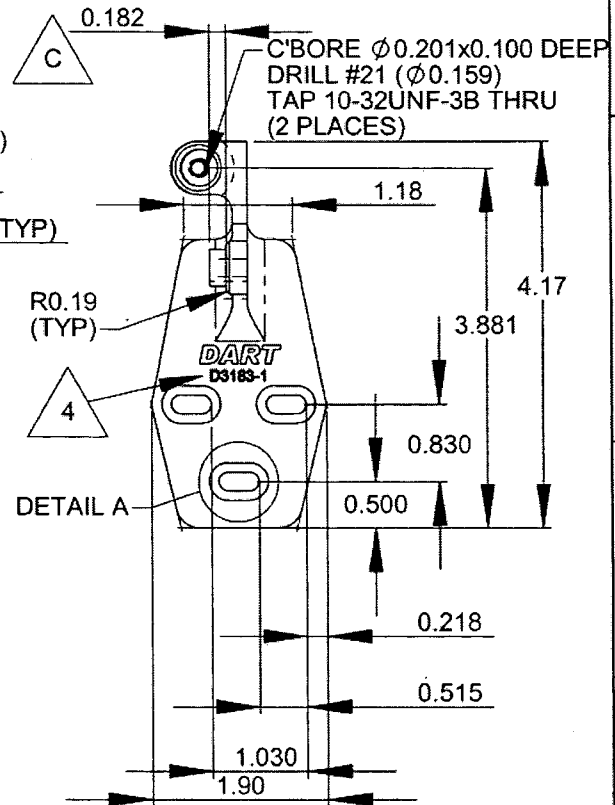
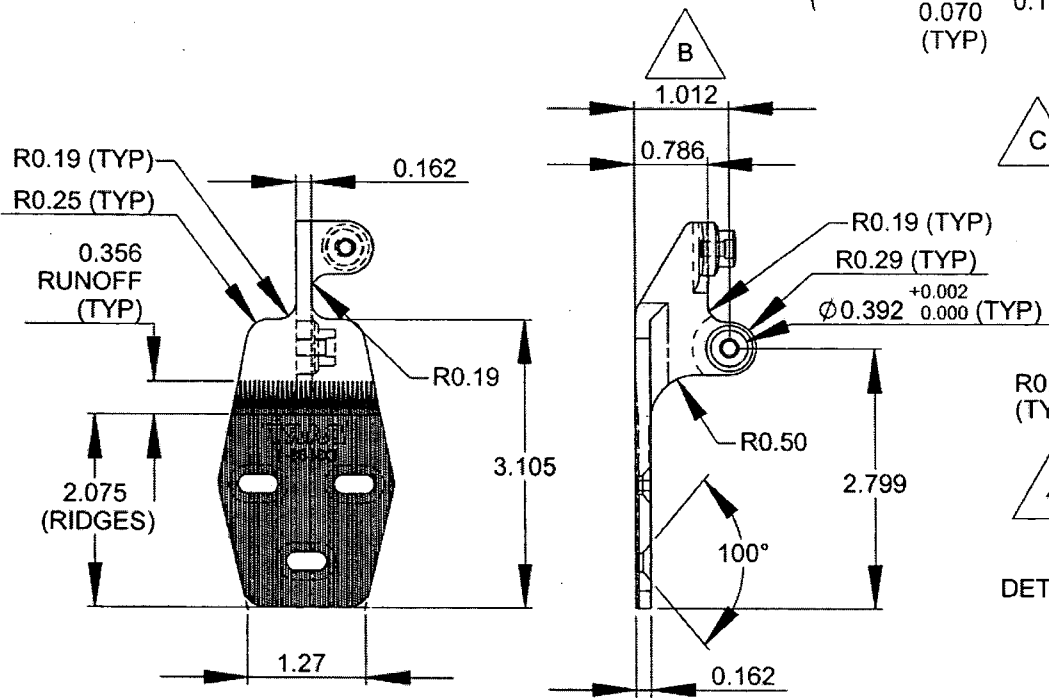
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		D3183	SHEET 2 OF 4
DATE	TITLE		SCALE
04.02.17	BRACKET ASSEMBLY		1:2

Technical drawing of a mechanical part showing a cross-section. The drawing includes the following dimensions and features:

- Top surface angle: 4.8°
- Horizontal distance from the left edge to the first vertical feature: 0.100
- Horizontal distance between the first and second vertical features: 0.070 (TYP)
- Horizontal distance between the second and third vertical features: 0.182
- Horizontal distance from the third vertical feature to the right edge: 0.536
- Top surface radius: R0.19 (TYP)
- Bottom surface radius: R0.063
- Detail callout: SEE DETAIL B (pointing to a circular feature on the top surface)
- Detail callout: B (pointing to a triangular feature on the bottom surface)



D3183-1 BRACKET SHOWN
D3183-2 BRACKET OPPOSITE

- 1) D3183-1 CAN BE MADE FROM D3183-3
D3183-2 CAN BE MADE FROM D3183-4
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ENGRAVE DART P/N & LOGO AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

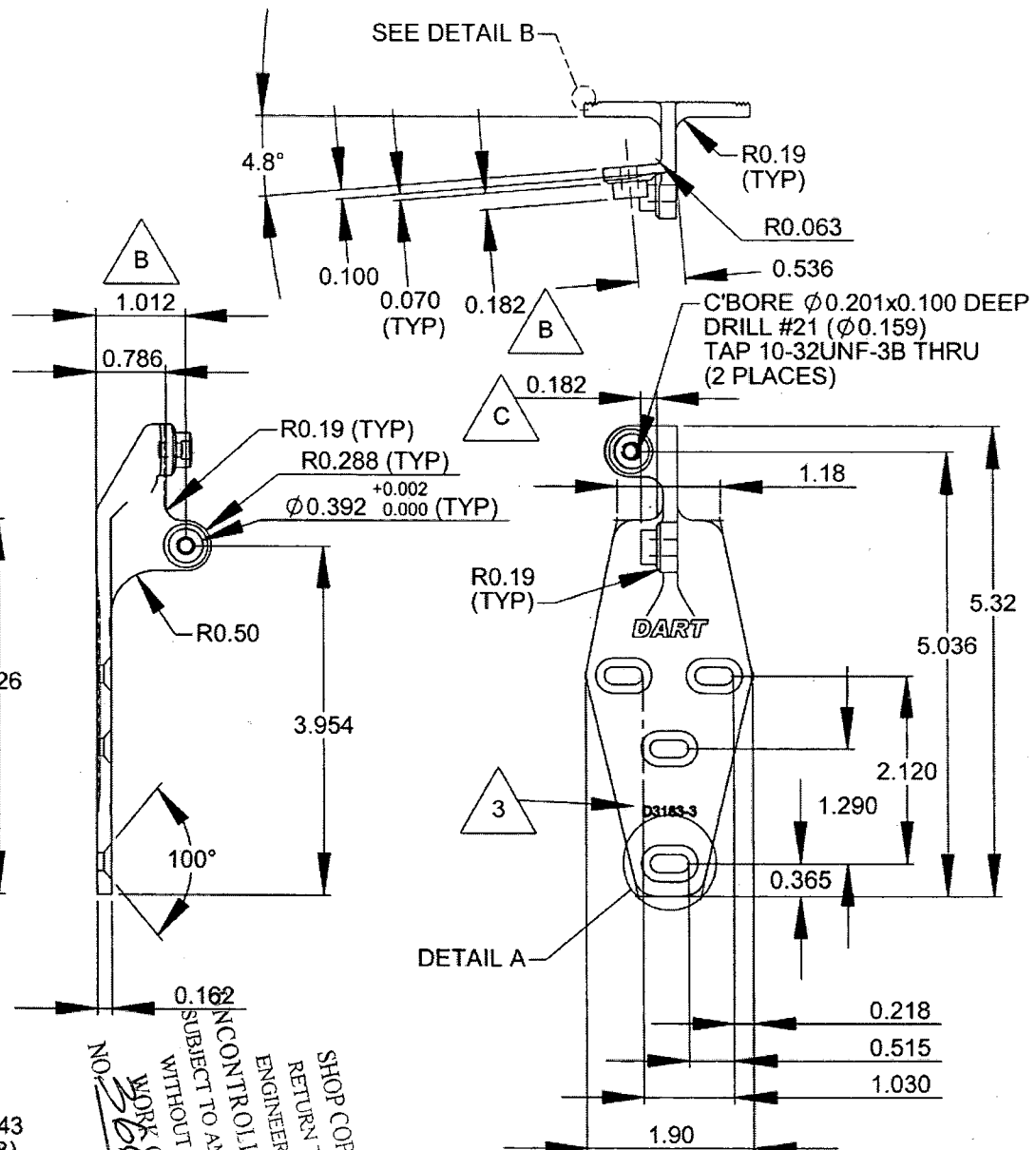
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DATE 04.02.17	DRAWING NO. D3183	REV. C
	TITLE BRACKET ASSEMBLY	SHEET 3 OF 4
		SCALE 1:2



D3183-3 BRACKET SHOWN
(REPLACES BELL P/N 412-030-304-105)
D3183-4 BRACKET OPPOSITE
(REPLACES BELL P/N 412-030-304-106)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) ENGRAVE DART P/N & LOGO AS SHOWN
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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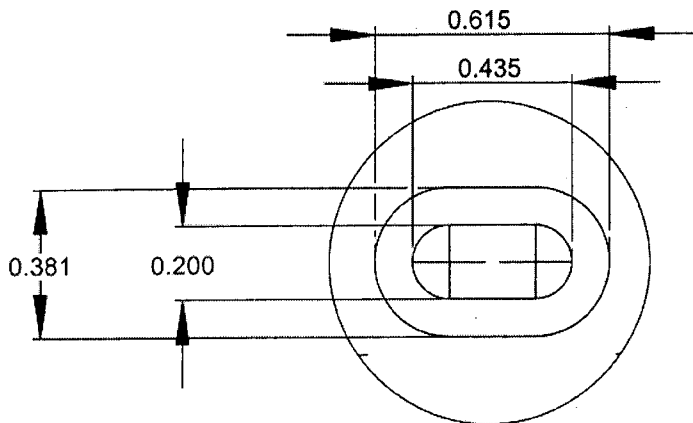
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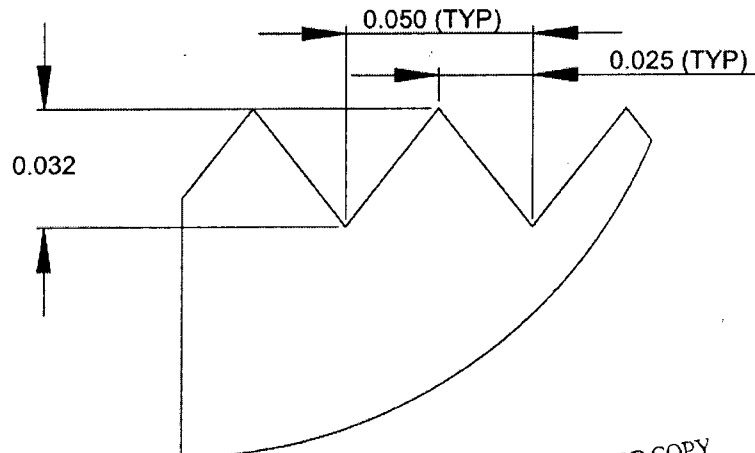


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3183	REV. C SHEET 4 OF 4
DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:1

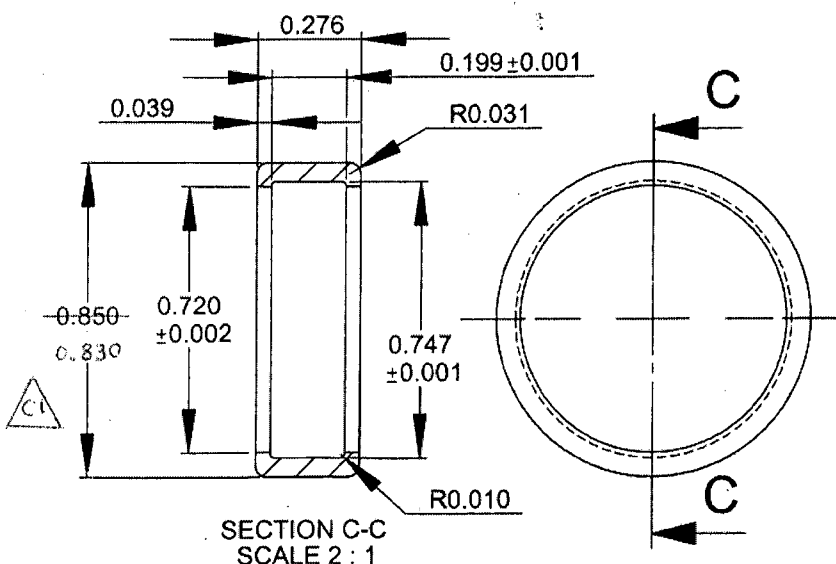


DETAIL A (2 : 1)

RELEASED
04.03.01 *[Signature]*



DETAIL B (20 : 1)



SECTION C-C
SCALE 2 : 1

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WORK ORDER
NO. **36638**

D3183-9 CAP

- 1) MATERIAL: DELRIN ROD, Ø1.00
(REF DART SPEC. M-DELRIN-R1.00)
- 2) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

D3183-045 BEARING ASSEMBLY

- 1) ASSEMBLE D3183-5 BEARING AND
D3183-9 CAP

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